

Door Skin Full Replacement		
<b>1</b>		<p><b>Door Frame Preparation</b></p> <p>Using a grade 80 abrasive belt, remove remaining weld nugget material from door frame. Clean and prep remaining mating flanges on door frame with a coarse Scotch-Brite™ Belt.</p>
<b>2</b>		<p><b>Clean</b></p> <p>Clean door frame and replacement panel mating flange areas with a VOC compliant surface cleaner.</p>
<b>3</b>		<p><b>Replacement Skin Prep</b></p> <p>Scuff replacement skin mating flange areas using Scotch-Brite™ Hand Pad.</p>
<b>4</b>		<p><b>Dry Fit Panel</b></p> <p>Dry fit replacement panel and complete any necessary metal straightening at flanges areas. Remove door skin in preparation for adhesive application.</p>
<b>5</b>		<p><b>NVH Replacement</b></p> <p>Apply NVH material at original locations on intrusion beam. For best results, re-attach existing foam with NVH material. In the absence of original foam, NVH material can be used in place of original foam.</p>
<b>6</b>		<p><b>Apply Bonding Adhesive</b></p> <p>Re-clean bonding surfaces with a VOC compliant surface cleaner. Apply adhesive to door frame covering all bare metal areas. Apply an additional bead of adhesive at mating flange areas to ensure proper bond line thickness.</p>
<b>7</b>		<p><b>Install Door Skin</b></p> <p>Install replacement door skin onto door frame. Crimp hem flange using hammer and dolly. Clamp as necessary. (For aluminum panels, follow OEM recommended flanging procedures.)</p>
<b>8</b>		<p><b>Clamp and Cure</b></p> <p>Follow recommended adhesive clamp and cure times. Clean any adhesive squeeze out from hem flange area with a VOC compliant cleaner.</p>
<b>9</b>		<p><b>Seam Sealing</b></p> <p>Re-apply seam sealer to hem flange as required following general seam sealing guidelines.</p>

Visit [3MCollision.com](http://3MCollision.com) for more SOPs and videos

**Product List**

3M™ File Belt Sander, 18 in., PN 33575



3M™ Cubitron™ II File Belt, grade 80+, PN 33446



Scotch-Brite™ Durable Flex Belt, CRS, PN 64475



Scotch-Brite™ Durable Flex Hand Pad, MX-HP, 4-1/2 in. x 9 in., Very Fine, PN 64659



Scotch-Brite™ 7447 PRO Hand Pads, Very Fine, 6 in. x 9 in., PN 64926



3M™ NVH Dampening Material, PN 04274



3M™ Urethane Seam Sealer, PN 08361

3M™ MSP Seam Sealer, PN 08370

3M™ Panel Bonding Adhesive, 50mL, PN 38315; 200mL, PN 08115; 200mL, PN 08116; 450mL DMS, PN 58115



3M™ Composite and Metal Bonding Adhesive, 200mL, PN 08219



3M™ Bare-Metal Seam Sealer 200mL, PN 08310; 600mL DMS, PN 58310



3M™ EZ Sand Multi-Purpose Repair Material, 200mL, PN 05887; 600mL DMS, PN 55887



**Think About Your Health**

3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300



3M™ Half Facepiece Respirator, PN 07182



3M™ Virtua™ Protective Eyewear, PN 11326



## Individual Product Instruction and Safety Information

For individual product instructions and applicable precautions see product labels and associated literature for the individual product at [3MCollision.com](http://3MCollision.com)

For product material safety data sheets see [3MCollision.com](http://3MCollision.com)

**Technical Information:** The technical information, guidance, and other statements contained in this document or otherwise provided by 3M are based upon records, tests, or experience that 3M believes to be reliable, but the accuracy, completeness, and representative nature of such information is not guaranteed. Such information is intended for people with knowledge and technical skills sufficient to assess and apply their own informed judgment to the information. No license under any 3M or third party intellectual property rights is granted or implied with this information.

**Product Selection and Use:** Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. As a result, customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer's application, including conducting a workplace hazard assessment and reviewing all applicable regulations and standards (e.g., OSHA, ANSI, etc.). Failure to properly evaluate, select, and use a 3M product and appropriate safety products, or to meet all applicable safety regulations, may result in injury, sickness, death, and/or harm to property.

**Warranty, Limited Remedy, and Disclaimer:** Unless a different warranty is specifically stated on the applicable 3M product packaging or product literature (in which case such warranty governs), 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, OR ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE. If a 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price.

**Limitation of Liability:** Except for the limited remedy stated above, and except to the extent prohibited by law, 3M will not be liable for any loss or damage arising from or related to the 3M product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability.



3M Automotive Aftermarket Division  
3M Center, Building 223-6S-07  
St. Paul, MN 55144-1000  
U.S.A.

3M, Accuspray, Cubitron, E-A-R, Hookit, Platinum, PPS, Rocker Gard, Roloc, Scotch, Scotchblok, Scotch-Brite, Skull Screws, Trizact and Virtua are trademarks of 3M Company. All other trademarks are property of their respective owners.

Web [3MCollision.com](http://3MCollision.com)

Please recycle. Printed in U.S.A. © 3M 2019. All rights reserved. Rev 7/19.

60-4402-8071-1